



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-93

Job Sheet 190624



Part No: 20NR-93

Job Qty: 4 pcs

Part Name: Stop Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/12/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-93 Rev.0 IPP Rev. A 19.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NV5000 - 1	4 pcs	3/15/19		0.00	8.00	NV5000 - 1		DJ 19-04-05
							NV5000 - 2		
110	QC 2	4 pcs	3/15/19		0.00	0.00	QC 2 - 1		DJ 19-04-05
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C. 19-04-06
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S170191



Part: 20NR-93

Job No: 190624

Serial No/Batch: S170191

Revision: 0

Inspector:

Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/06/19

120	QC 8	4 pcs	3/15/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.A 19-04-07
					QC 8 - 9	
					QC 8 - 68	
130	Outsource - 15 - Nickel Plate	4 pcs	3/15/19		GRO002-VC	04/09/2019 PL
140	Packaging 2-1 - Receive - B4B	4 pcs 10 pcs	3/15/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DF APR 15 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
150	QC 6	4 pcs	3/15/19	0.00 0.00	QC 6 - 42	DAS
					QC 6 - 9	APR 16 2019
					QC 6 - 68	40
					QC 6 - 61	9-89
160	Packaging 3-1 - Stock - B4B	4 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	

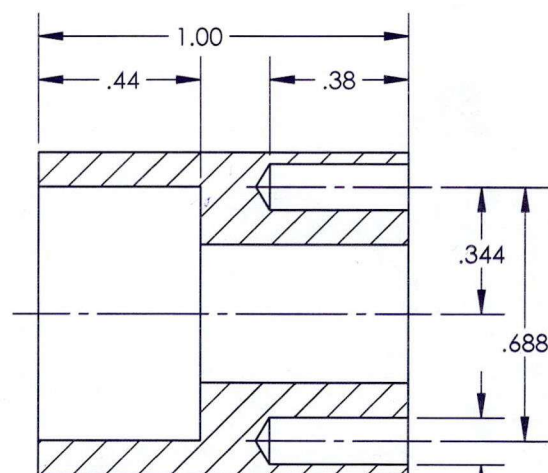
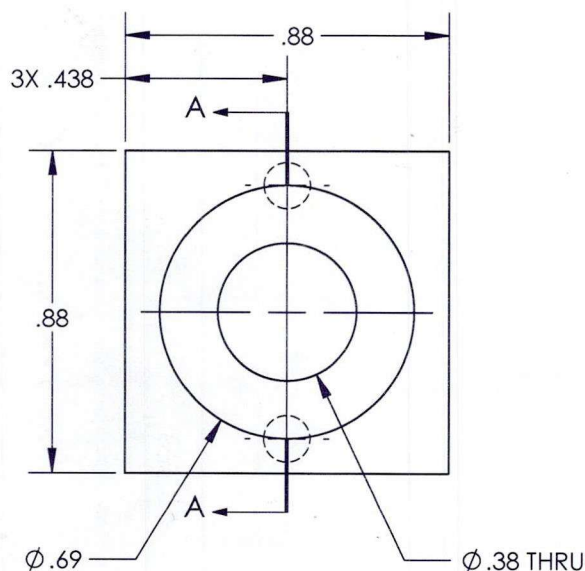
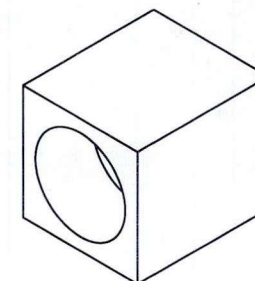
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				170 QC 21 - SA	4 pcs
				QC 21 - SA - 70	
Part Op 100 - 1-Machine as per folio FC <u>739</u> FOLIO REV: <u>A7</u> DWG REV: <u>0</u> 2-Deburr <u>9-89</u> Descriptions: 130 - -Issue P/O; <u>043152</u> -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required 140 - Certificate of Conformity is required					DAS APR 18 2019 70
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M1018B1.000X01.000	1010-1025 Steel Bar 1.000 X 1.000	.4160 ft (.104 ea)	100-NV5000 - 1	<u>5048661</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NV5000 - 1	M1018B1.000X01.000	0	0	0	
Part Specifications					
Specifications could not be found.					

MAT
Lives
1.037

Plex 2/12/19 11:01 AM Dart.lajeunesse.marie

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
	AS DRAWN BY CANAM	8/6/2013	CFS



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 190624 MWS
19-02-12

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.

USED ON
20NR-DHC
8NR-DHC
20NR-DHRC
8NR-DHRC
20NR-DHCA
8NR-DHCA

RED BARN MACHINE	
STOP BLOCK	
DWG NO. 20NR-93	REV
MATERIAL A36	
DRAWN BY: CANAM	
APPROVED: <i>D Weir</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/32	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 3/12/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-93	1	STOP BLOCK	A36	7/8 X 1 X 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043152



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO043152
PO Date: 4/9/19
Due Date: 4/15/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Attention: Grenon, Sylvie

Via: Ground
Pymt Terms: Net 60

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192960	20NR-54	Lock Bearing Pin -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed - X20	-	4/15/19	20 pcs	0 pcs	20 pcs	\$6.666/pcs	\$133.32
APR 15 2019 DP											

Line Item Note *** NEED BACK APRIL 15,2019 ***

2	191272	20NR-72	Light Release Pivot Bushing (Outside Processing - Nickel Plate)-Issue P/O to GROUPE ALTECH: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed - X6	-	4/15/19	6 pcs	0 pcs	6 pcs	\$6.666/pcs	\$40.00
APR 15 2019 DP											

Line Item Note *** NEED BACK APRIL 15,2019 ***



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PURCHASE ORDER

PO043152



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
31	190624	20NR-93	Stop Block -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	4/15/19	10 pcs	0 pcs	10 pcs	\$6.666/pcs	\$66.66

X10

APR 15 2019

DP

DAS
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9-89

Line Item Note *** NEED BACK APRIL 15,2019 ***

Grand Total: \$239.98

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/10/19 8:47 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018362-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

018362 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
11-Apr-2019		SVETLANA DORZHIYEVA				043152			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	20NR-54 Rev.	20NR-54 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE 0.0004 TO 0.0006 BAKE AFTER PLATING		E-NICKEL-200 CH	20	20	0	0	0
2	20NR-72 Rev.	20NR-72 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING		E-NICKEL STEEL CH	6	6	0	0	0
3	20NR-93 Rev.	20NR-93 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE 0.0004 TO 0.0006 BAKE AFTER PLATING		E-NICKEL-200 CH	10	10	0	0	0

DAS
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9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.